

Date: Monday, 11/21/2005 7:08:01 PM  
User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B SCUFF PLATE  
Job Number : 24817  
Estimate Number : 10825  
P.O. Number : N/A Part Number : D206555004  
This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D206-555 REV B  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
Previous Run : N/A Material : N/A  
Due Date : 12/30/2005 Qty: 10 Um: Each  
Written By : SEE COMMENT BELOW  
Checked & Approved By : SPE ABOVE USER & DATE  
Comment : Est Rev:E 99.06.29 Returned to Electro Polish DM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-004

2.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 146

Email or ship DXF file to vendor Laser cut part as per DXF file

Material release note required

u

05-11-22

(10)

3.0

D206555004F

SCUFF PLATE FLAT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

SCUFF PLATE FLAT

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

CL 06/01/19

(10)

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J 0601-19 10

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B SCUFF PLATE

Job Number: 24817

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form parts on hydraulic press as per Dwg. D206-555 using DT 8316-4

SB 06/02/28

2-Finish form on bench forming Jig DT 8317-4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 680

u 06-08-28

Electro Polish

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage

06/3/14

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

06-03-14

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

N/A

subcontract

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-14

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 06-03-14

N/A

see W10# B26008

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B SCUFF PLATE

Job Number: 24817

Part Number: D206555004

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP* 06/03/15 *(10)*

Job Completion



*U 06.03.14*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-14	13	Parts electro-polished on w/o 26008 custom. P/O 680 Identify and stock as per w/o B26008.	CL	06/03/14	10	U 06-03-14	 06-03-14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LS Date: 06/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

□□□□□□□□

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024817	Department Code:	
Project Name	: D206-555-004	Burden Flags	: NNNNNNNN
Project For	: WK602	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D206-555-004	Invoice Number	:
Description	: Scuff Plate Aft RH 206B	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 01-10-06	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	-0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

N27714

24ga 48 x COIL

304 2B

020001837

总页数:  
Total Pages

1

页号:  
Page No.

1

品名:  
Commodity

304 2B

牌号:  
Type

304

标准: ASTM A240-01 AND ASME SA240-01  
Specification表面加工:  
Surface

2B

客户名称:  
Customer

MIDLAND RESOURCES HOLDING LIMITED

订货者:  
Order

MIDLAND RESOURCES HOLDING LIMITED

目的地:  
Destination

SEATTLE

合同号:  
Contract No.

BXML-043

证明书号:  
Certificate No.

200212686

发行日期:  
Date

2002年12月27日

客户管理号:

8101

Customer's Control No.

生产许可证编号:

浙工许办[2002]20782号

The Permit No. Of Produce

序号 Item No.	捆包号 Case No.	冷卷号 Coil No.	炉号 Heat No.	规格尺寸 Size(mm)	数量 Quantity	重量 Mass(kg)	化学成分 Chemical Composition in %									
							C	Si	Mn	P	S	Ni	Cr	Mo	N	Ti
1	2B02912	WC2567C	N27714	24GA(0.024")*48"COIL	1	5003	0.06	0.49	0.79	0.026	0.012	8.06	18.24		0.029	

合计 Total

序号 Item No.	拉伸试验 Tensile Test				硬度试验 Hardness	弯曲试验 Bend	晶间腐蚀 Corrosion Tests
	屈服强度 0.2% Yield	屈服强度 1% Yield	抗拉强度 Tensile Strength	伸长率 Elongation	HRB	180°	
最大 MAX.	MAX.		MAX.	MAX.	92		
最小 MIN.	30		75	40	MIN.		
1	43		102	57	87		

我们保证上述数据都是真实的, 准确的。

We hereby certify the above statement to be true and correct every detail.  
Ningbo Baoxin Stainless Steel Co., Ltd, Baosteel Group.

45002738

P014146

检查证明书  
INSPECTION CERTIFICATE

宁波宝新不锈钢有限公司

NINGBO BAOXIN STAINLESS STEEL CO., LTD.

地址: 浙江省宁波市北仑区霞浦镇

Add: Xiapu town, Beilun District, Ningbo

电话: (0574) 86907888

Tel: (0574) 86907888

传真: (0574) 86907128

Fax: (0574) 86907128

邮编: 315807

P.C: 315807

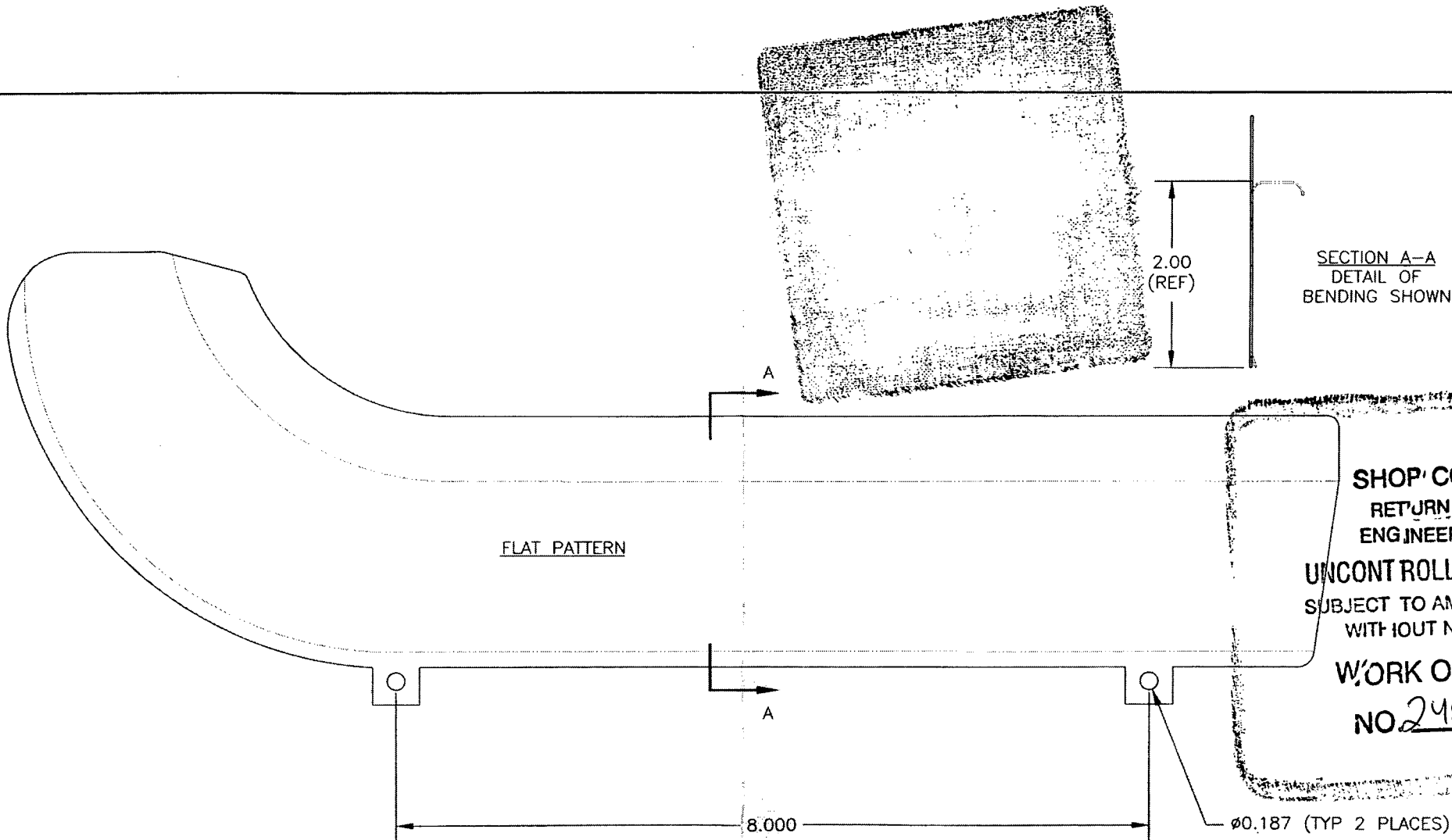


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D206-555	REV. B SHEET 1 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	

RELEASED  
99.01.11 KE

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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WITHOUT NOTICE  
WORK ORDER  
NO 24817



D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
D206-555-002 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T1  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE

DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD BURLINGTON, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D206-555	REV. B SHEET 2 OF 7
DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1



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WORK ORDER  
NO. 24817

2.00  
(REF)

SECTION C-C  
DETAIL OF  
BENDING SHOWN

DETAIL B  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

FLAT PATTERN

8.000

8.000

Ø0.187 (TYP 3 PLACES)

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)

D206-555-004 (BEND OPPOSITE)

BEND PER M/F TEMPLATE D206-555-T3



MATERIAL: AISI 304/316 0.020 THICK

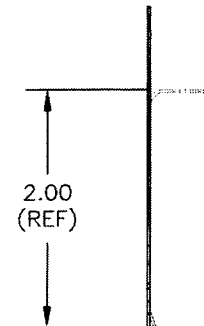
FINISH: BRIGHT COLD ROLLED (2B)

NO SCRATCHES ON SURFACES

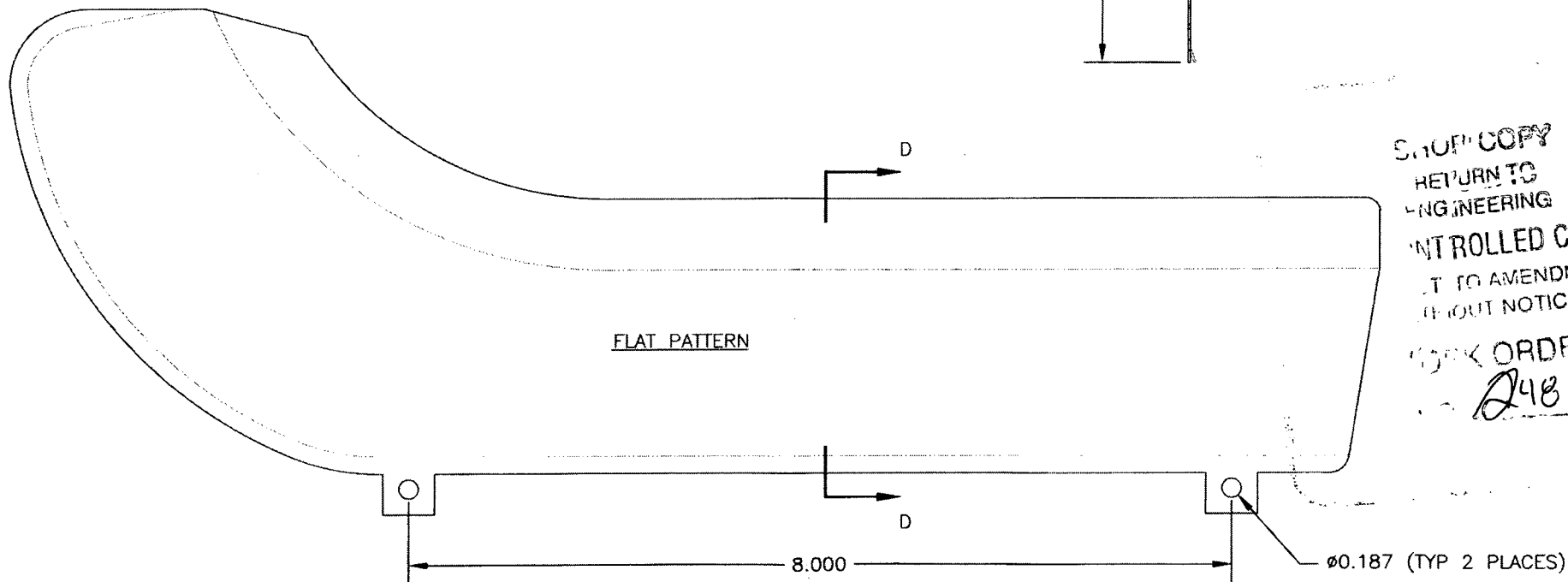
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE

DESIGN 	DRAWN BY 	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. B
CHECKED 	APPROVED 	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	SCALE 2:1	



SECTION D-D  
DETAIL OF  
BENDING SHOWN



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WORK ORDER  
24817

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)  
D206-555-006 (BEND OPPOSITE)

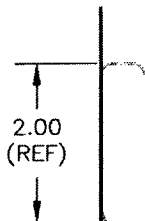
BEND PER M/F TEMPLATE D206-555-T5  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

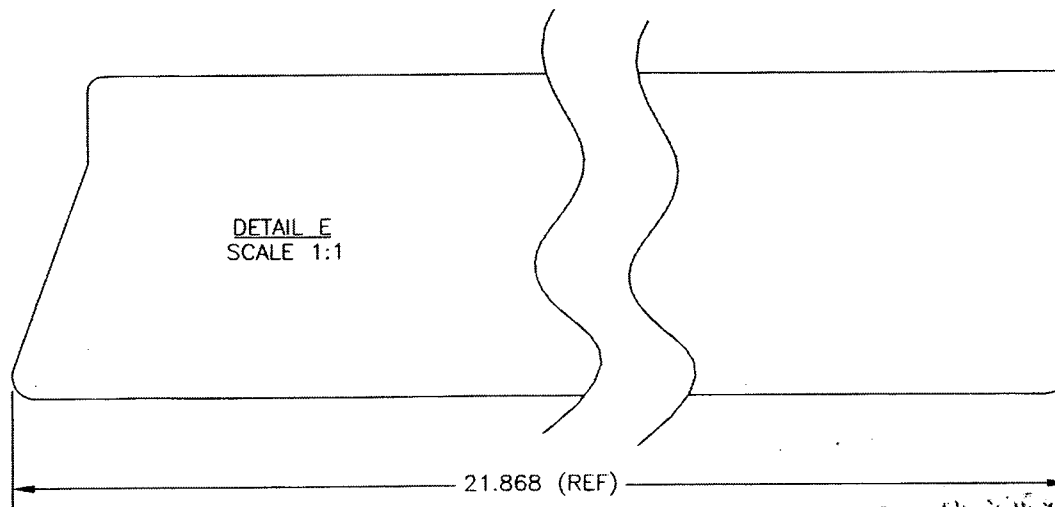
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99.01.11 KE



DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
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DATE 98.10.26		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1



SECTION F-F  
DETAIL OF  
BENDING SHOWN



DETAIL E  
SCALE 1:1

21.868 (REF)

REFER TO DETAIL E  
FOR 1:1 SCALE

FLAT PATTERN

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WITHOUT NOT  
WORK ORDER

24817

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

BEND PER M/F TEMPLATE D206-555-T7

MATERIAL: AISI 304/316 0.020 THICK

FINISH: BRIGHT COLD ROLLED (2B)

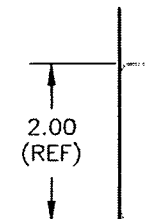
NO SCRATCHES ON SURFACES

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
99.01.11 KE



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART</b> DART AEROSPACE LTD WINDRESSBURY, OXFORD, ENGLAND	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 98.10.26	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



SECTION H-H  
DETAIL OF  
BENDING SHOWN

DETAIL G  
SCALE 1:1

16.000 (REF)

H  
#10-18-28  
CP 0.08-28

REFER TO DETAIL G  
FOR 1:1 SCALE

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WITHOUT NOTICE  
WORK ORDER  
24817

FLAT PATTERN

8.000

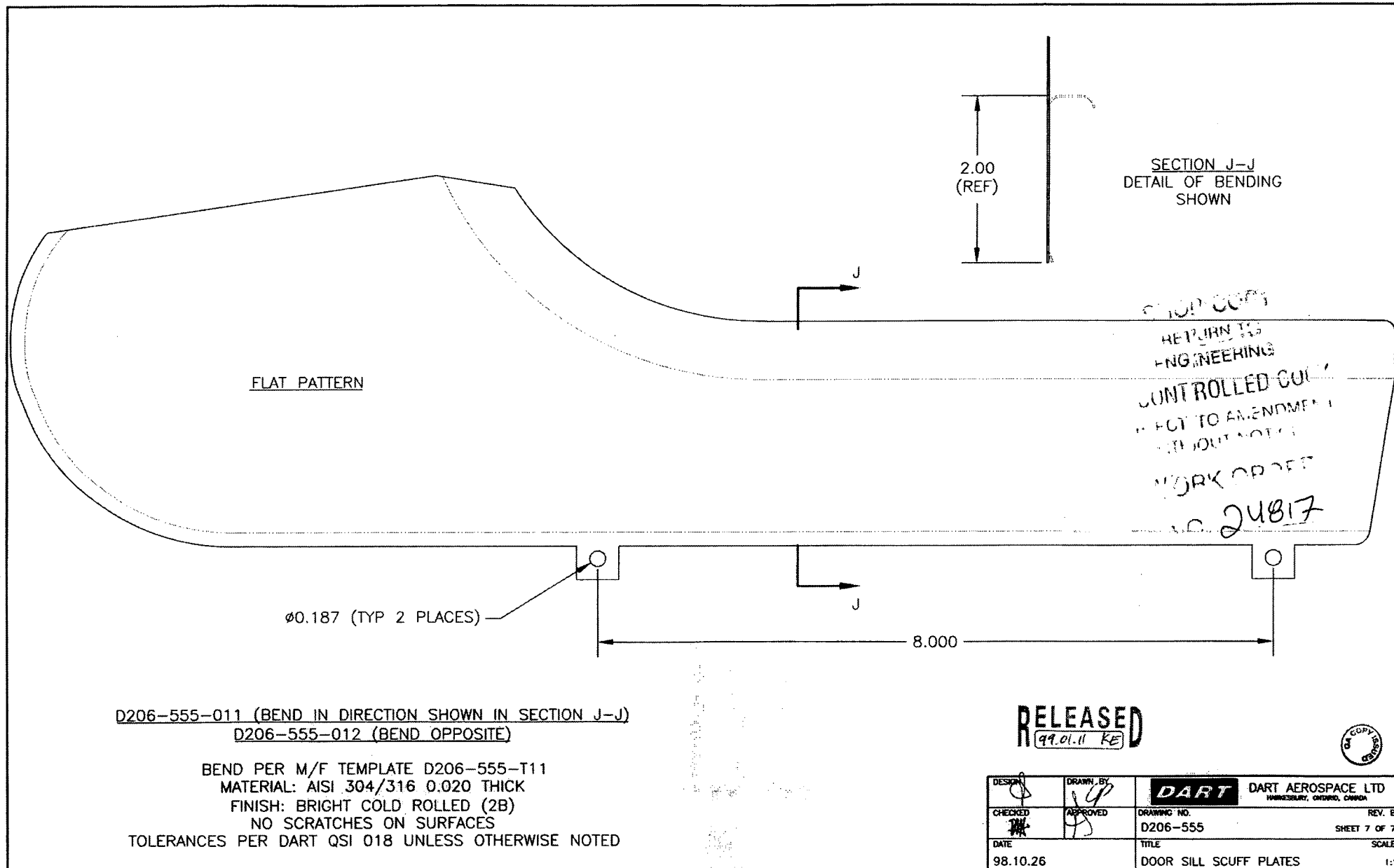
8.000

Ø0.187 (TYP 3 PLACES)

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

BEND PER M/F TEMPLATE D206-555-T9  
MATERIAL: AISI 304/316 0.020 THICK  
FINISH: BRIGHT COLD ROLLED (2B)  
NO SCRATCHES ON SURFACES  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN 	DRAWN BY 	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	
DATE 98.10.26	DRAWING NO. D206-555	REV. B SHEET 6 OF 7
	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: March 9, 2006

1270 Aberdeen St

Hawkesbury, Ontario

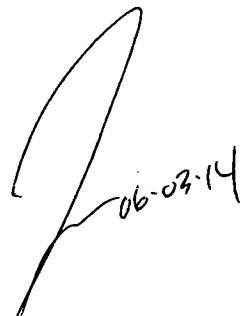
No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053

**C100880**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
111087	96	NO. DE COM./P.O.# 680 MISC-0434-550	ELECTROPOLISH PER BAPS 160-036 REV.NC, (REMOVE .0001 -.0002")
			

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.

G. Persaud / G. McPhee

Total Quality Finishing